

Date: Thursday, 11/15/2007 1:27:13 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW RING
Job Number : 35780	
Estimate Number : 10794	
P.O. Number : N/A	Part Number : D3407041
This Issue : 11/15/2007 S.O. No. : N/A	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 34010	Material : N/A
Written By : N/A	Due Date : 12/5/2007 Qty: 21 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 05.10.14 New issue KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34071	Stem
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3407-1	Stem	635364

FC 07/11/26 (21)

2.0	D34075	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3407-5	Ring	634708

FC 07/11/26 (21)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD Batch: m101972

FC 07/11/26 (21)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

ID 07-11-28 (21)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 07/11/28 (21) county

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: TOW RING

Job Number: 35780

Part Number: D3407041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*Mask Threaded Section\*\*

07-11-29

(X21)  
21X

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/11/29

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 460

KS 07/11/29

(X21)  
21X

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/30

Job Completion



07/11/30

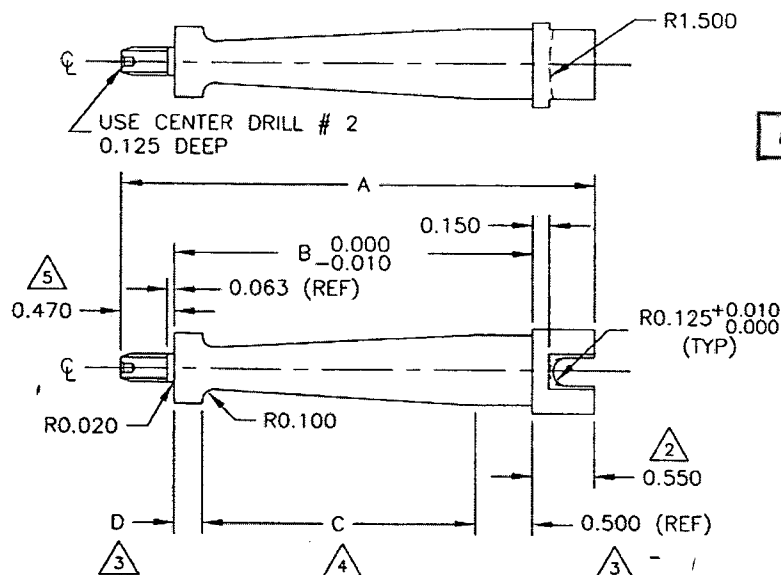
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification, Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

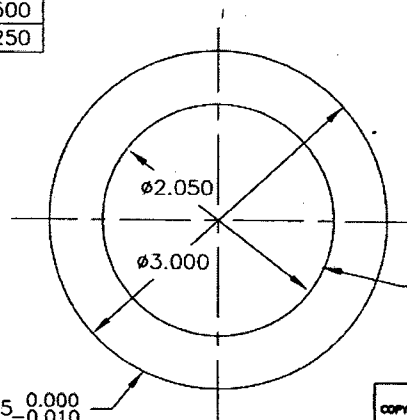
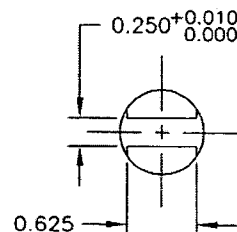
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

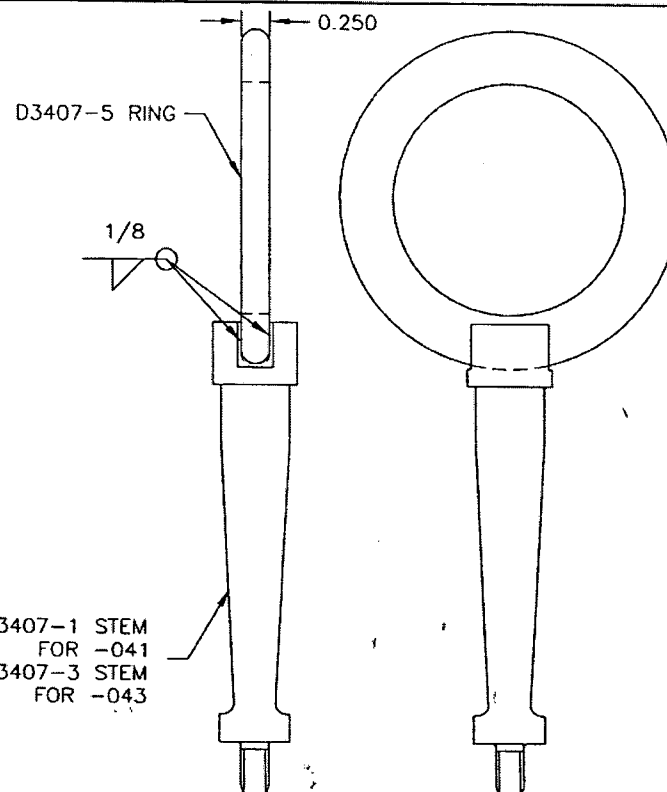
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05 09.12



### D3407-5 RING



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	*UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	CP
CHECKED	✓	APPROVED
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 0
SHEET	1 OF 1	SCALE
		1:1

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ENGINEERING  
RETURN TO  
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35780  
WORK ORDER  
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WITHOUT NOTICE